										0 4	Jan 1
Work Orde Thursday, Octob				* <u>9</u> 1	972*	`	Din	rju	Page 1		
Revision ID:	D206-728-41 Skidtube Prote			Accept	*N900	040	100)* s	Setup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	10/18/2012 10/18/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item II Customer:	D:					
Approvals:	Process Pla	n:	Date:	Tooling:	Da	te:		R	Run Sta	1/7	R1*
	QC:		Date:	SPC (Y/N):	Da	te:	-		Sto	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D407-728	Rev	A		- ·							
*100 *100* DC Document Control		DOCUMENT CONTROL Memo Photocopy b		0.00 A 0.00 S 0.0	2/w/c						
110		Pick-Kit		0.00							
110 Packaging Packaging		Memo		0.00							2-10
*120		QC4- 100% Inspect kits f	or completeness	0.00	6) Nole						
QC		Мето		0.00	and to to the						

Quality Control

									DQA:	Date:	
NCR: Yes	/ No	-		WOR	K ORDER NON-	CONFOR	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is ork Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of v	work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	or Non-co	onformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling]		·								
Operator											
Material							:				
Setup											
Other											
Process						J.E.					
Supplier]					***					
Training]		1								·
Unapproved											
					F	AULT CAT	GORY				
Landing	Gear				General						_

	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
Г	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
Γ	Wave/Twist in Tube	Folio	Outside Dimensions		

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Work Orde Thursday, Octob				*910	72*				Page 2
Revision ID:	D206-728-41			Accept	*N900	040100)* Setu	p Start Stop	*NS1*
	10/18/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		осор	*NS2*
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	•		pack for shipping as pe : PPP R	Set Up/ Run Hours 0.00 0.00 or PPP D206-728-	Tool ID	Tool # Plan Code	A .	•	Reject Insp. Number Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

Quality Control

Memo

0.00

MLJ 12-10-18 ML 12-10-18

										DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-O	CONFOR	RMANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N						Rework Scrap Use-as-is	The	Skid-tube Machining rmoforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo					Work Order Update] Ine	Large Fab	Composite	Nec/3to	Supplier	J Other
Root					Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause] [ate	Step	Qty	. (or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
oc/Data												
quip/Tooling							i					
perator	_							,				
⁄laterial					} {							
etup												
Other					**							
rocess	_											
Supplier	_											·
raining	_											
Inapproved			<u> </u>							<u> </u>	<u> </u>	
							AULT CAT	EGORY				
Landin						General	<u> </u>			1	_	7. ,
-		Bending Bend			Grain		<u> </u>	Ovalized	<u> </u>	Pressure/Forced		
	Centre Not Concentric to O/S			ntric to	o/s	BOM/Route	Hard		<u> </u>	Over/Under	_	Temperature/Cure
}	Cracks			<u> </u>	Broken/Damaged		ction Incomplete		Part Incorre	├	Weld	
	Crushed/Crimped.				<u> </u>	Burrs	—	ictions Incomplete,	/Unclear	Part Lost/M		Wrong Stock Pulled
ļ	Cuffs			Contamination		tenance	<u> </u>	Part Moved				
	Heat Treat			<u> </u>	Countersink		beled		Positioned \		1	
ł	Inspection Strip in Tube			Tube		Cut Too Short	Misre	ad	1	Power Loss,	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Page 1

Work Order ID:

91972

Parent Item:

D206-728-413

Parent Item Name:

Skidtube Protector

Start Date: 10/18/2012

Required Date: 10/18/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:	Rev IPP: A 05	.10.19New issueKJ	/EC										
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10L Washer	NAS1149D0332J	Purchased	No			120	Each	0.0000	<u> </u>	38	229		SP
D3340-15 Center-Skidtube Protector		Manufactured	No			120	Each	12.0000		1			01 =
				Location		Loc Qty	Lo	c Code					
\				ST501		12				104			
D3340-17 Aft Skidtube Protector		Manufactured	No	2519	4	12 120	Each	7.0000		\$ / 7 7 1			
`				Location		Loc Qty	<u>Lo</u>	c Code					
,				ST501		7				2 (2 6			
D3340-19 Center Skidtube Protector		Manufactured	No	7313	9	7 120	Each	6.0000	1	3/33 1	- (
				Location		Loc Qty	<u>Lo</u>	c Code					
				ST501		4							~/
				8172	1	4			£L	<i>72 </i>			
				ST502		2						•	

73278

										•		DQA:	Da	ite: _	
NCR: Y	'es /	No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE					
												QA Closed:	Da	ite:	į
Work Orde	\r.					DISPOSITION				AGAINS	T DE	PARTMENT,	/PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update Skid-tube Machining Thermoforming Large Fab			Crosstub Small Fa Finishin Composit	b g				Engineering Quality Other			
Root					Descri	ption of work order update		Initial	Ad	ction		Sign &		\Box	· · · · · · · · · · · · · · · · · · ·
Cause	D	ate	Step	Qty		or Non-conformance	Ct	nief Eng	Desc	cription		Date	Verificatio	'n	QC Inspector
Doc/Data									· · · · · · · ·						
Equip/Tooling															
Operator			I												
Material															
Setup											4.				
Other													,		
Process															
Supplier														1	
Training							1								χ,
Unapproved				<u> </u>											
						F	AUI	LT CATE	GORY						
Landir	ng Gear					General		_			_	_		_	
	Ben	ding				Bend		Grain				Ovalized			Pressure/Forced
	Centre Not Concentric to O/S		o/s	_BOM/Route	<u>_</u>	Hardware			<u> </u>	Over/Under		Ш	Temperature/Cure		
	Cra	cks				Broken/Damaged		Inspect	on Incomplete			Part Incorre		\vdash	Weld
	Cru	shed/Cr	imped.			Burrs		Instruct	ions Incomplete,	/Unclear	L	Part Lost/M	issing		Wrong Stock Pulled
] [Cuffs				Contamination		Maintenance				Part Moved				

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

Thursday, October 18, 2012 3:17:27 PM

Page 2

Work Order ID:

91972

Parent Item:

D206-728-413

Parent Item Name:

Skidtube Protector

Start Date: 10/18/2012

Required Date: 10/18/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

110

Each

1,236.0000

Location	Loc Qty	Loc Code	
308	170		
122452	170		
ST291	672		
117423	71		
119075	1		
120308	44		
121011	43		
121243	500		
121708	13		
ST305	394		
123265	394		384

											DQA:	Date:	
NCR:	Yes	/ No	,			WORK ORDER NON-C	100	NFORM	MANCE / UPDATE		·		
									·		QA Closed:	Date:	
Work Ord	or:					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS	
WOIK OIG	٠				 _	Rework	1		Skid-tube Crosstu	he		Water Jet	Engineering
Part I	Vo.					Scrap	1	i	Machining Small F	· -	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming Finishi	-		re/Packaging	Other
NCR f	No.					Work Order Update	1		Large Fab Composi	ite		Supplier	
					:								· · · · · · · · · · · · · · · · · · ·
Root				r.		otion of work order update	1	nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description		* Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator	Ш												
Material											į.		
Setup													
Other													
Process	Ш		:										
Supplier	Ш											: :	
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Unapproved				<u> </u>	<u> </u>		<u> </u>				<u> </u>		
			<u> </u>			·	AUL	T CATE	GORY				
Landi	ng (General		1		_	1	_	, 7
		Bending				Bend	<u></u>	Grain		_	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	\vdash	Hardwa		\vdash	Over/Under	 	Temperature/Cure
		Cracks			_	Broken/Damaged		1	ion Incomplete	-	Part Incorre	⊢	Weld
	<u> </u>	Crushed/	Crimped.	-		Burrs	<u></u>	4	ions Incomplete/Unclear	<u> </u>	Part Lost/M		Wrong Stock Pulled
		Cuffs			·	Contamination	\vdash	Mainte		\vdash	Part Moved		
		Heat Trea	it			Countersink		Mislabe		-	Positioned \		٦
1		Inspection	n Strin in	Tube	1	Cut Too Short	1	Misread	1	1	Power Loss	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion



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206 L/L1/L3/L4 SERIES & 407 HIGH/LOW GEAR SERIES and 206 L/ L1 /L3/ L4 & 407 FLOAT GEAR SERIES

Qty	Qty	Qty -313	Qty 7	Qty -315	Qty -415	Part Number	Description
-311	-411	-313	(<u>-413</u>	-315	-415		206 L/L1/L3/L4 LOW GEAR & 407
							HIGH/LOW GEAR
X						D407-728-311	REPLACEMENT WEARPAD KIT
-^-	X					D407-728-411	SKIDTUBE PROTECTOR KIT
			\vdash			D407-720-411	SKID TOBE T KOTEOTOK KIT
							206 L/L1/L3/L4 HIGH GEAR
		X				D206-728-313	REPLACEMENT WEARPAD KIT
			х	-		D206-728-413	SKIDTUBE PROTECTOR KIT
			<u> </u>			D200-720-410	OKID TODE T KOTE OTO K KKI
				.,,,			206 L/L1/L3/L4 & 407 FLOAT GEAR
			\vdash	X	-	D407-728-315	REPLACEMENT WEARPAD KIT
			-		X	D407-728-415	SKIDTUBE PROTECTOR KIT
						5101.120 110	
5		6		7	1	D3339-3	CENTER WEARPAD
1				-	·	D3339-5	FORWARD WEARPAD
		1		1	_	D3339-7	LONG FORWARD WEARPAD
1		•		1	1	D3339-9	AFT WEARPAD
			 		_ 		
	1					D3340-7	FORWARD SKIDTUBE PROTECTOR
	1					D3340-13	AFT SKIDTUBE PROTECTOR
_	-		1		1	D3340-15	CENTER SKIDTUBE PROTECTOR
		l — ⁴	71	, and	<u> </u>	D3340-17	AFT SKIDTUBE PROTECTOR
_		 	71_			D3340-19 /	CENTER SKIDTUBE PROTECTOR
	l				1	D3340-21	AFT SKIDTUBE PROTECTOR
		 			1	D3340-25	FORWARD SKIDTUBE PROTECTOR
					<u> </u>		
28	28	38	/38	-46	-46	MS27039=1=08	-SGREW
28	28	38	/38	46	46	AN960JD10L	WASHER
				8	8	NAS1330C3K116	BLIND INSERT

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